

Work Order ID 52324 - 2

Tuesday, September 22, 2009 3:09:30 PM



Page 1

Item ID: D3405-043

Revision ID: B

Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00

Required Date: 10/9/2009 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Approvals: Process Plan: RL

Date: 9/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3405

Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3405
Deburr if necessary

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 2-

364
.125

HB 9-10-13

(15)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

HB 9-10-13

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

2) 8/10/13

(15)

Work Order ID 52324

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Page 2

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

Debur Form using DT8204 as per Dwg D3405

8/29/10/19

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/30/10/19

(X15)

150



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Weld as per Dwg D3405 Identify as D3405-043

9-1-30 (X3)

Work Order ID 52324

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Page 3

Item ID: D3405-043	Accept		Setup Start	
Revision ID: B			Stop	
Item Name: Lug Assembly				
Start Date: 9/23/2009	Start Qty: 12.00		Cust Item ID:	
Required Date: 10/9/2009	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(3)			09/11/30
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		⇒ 5 09/12/09		(x3)	/		
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 7:50 FINISH TIME: 8:20	0.00 0.00		BR 09-12-02		(3)			

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Page 4

Item ID: D3405-043

Revision ID: B

Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00

Required Date: 10/9/2009 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

PL 09/12/02

(X3) 0

200



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

474

9/12/2 (34) SP

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/12/03

PL 09-12-3 (3)

Picklist Print

Tuesday, September 22, 2009 3:09:30 PM

Page 1

Work Order ID: 52324



Parent Item: D3405-043RevB



Parent Item Name: Lug Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3404-1RevC 		Manufactured	No			100	Each	63.0000	12.0000			
GHW Lug												

EL 9-11-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

B52974 x3

ST

63

45372

8

50471

25

51548

30

M304S11GA

Purchased

No

150

sf

132.3156

1.9453

2.4316



304/316 0.125 Sheet

B 9-10-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

132.3155979

111018

4.31559789

112663

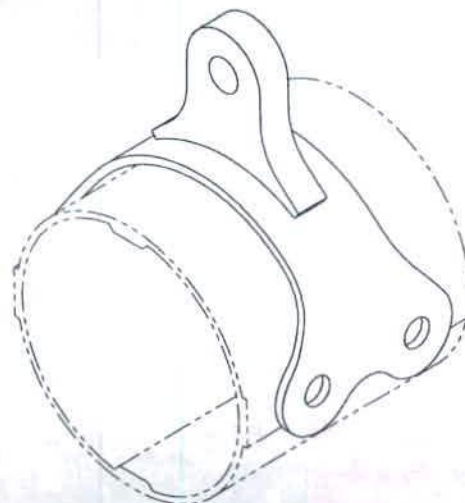
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111018

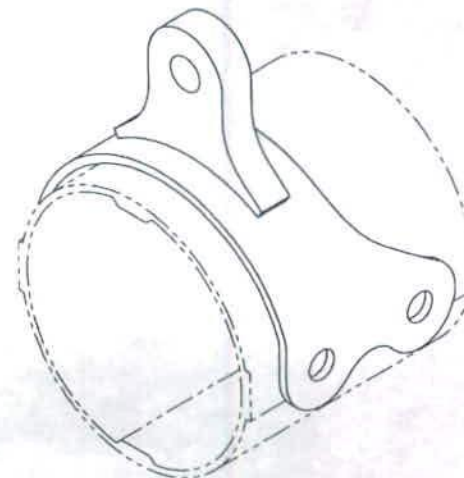
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52324



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

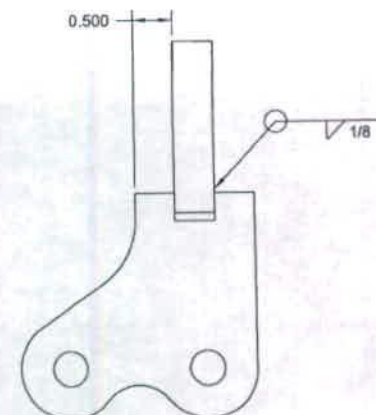
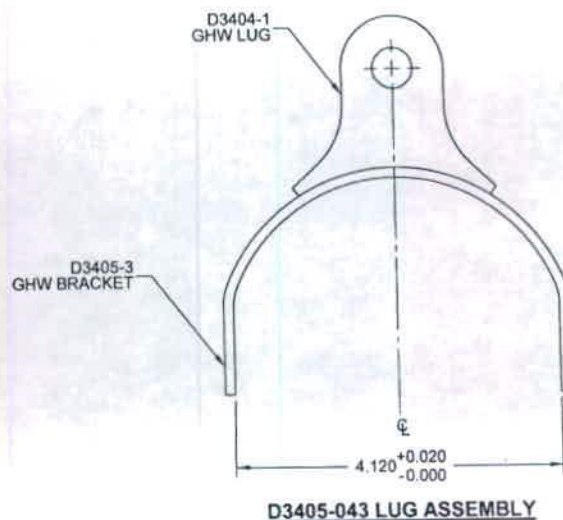
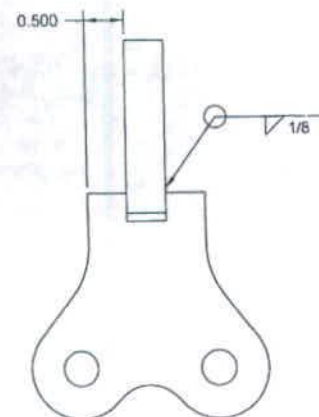
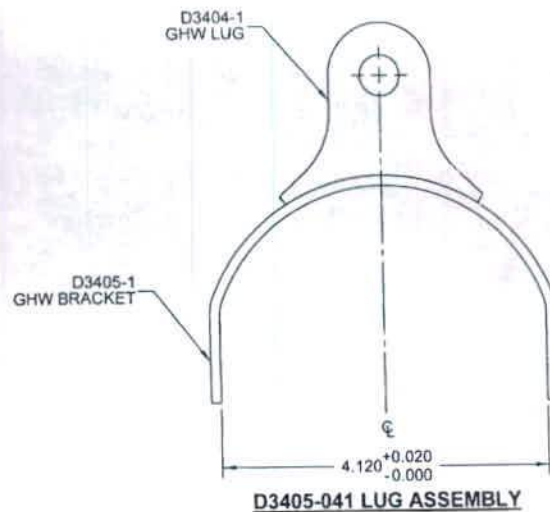
RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

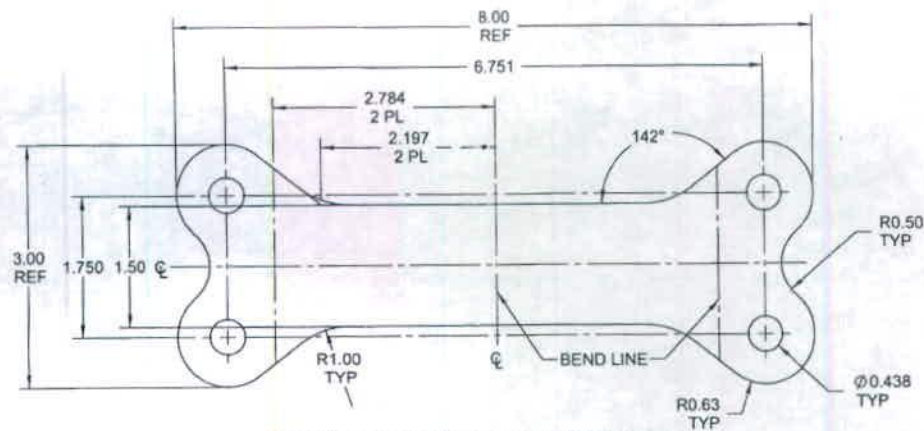
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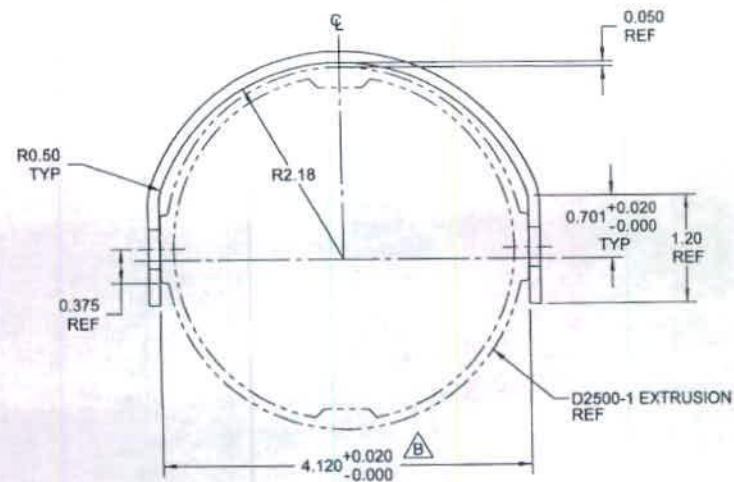
RELEASED
06/12/18 MJP

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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52324



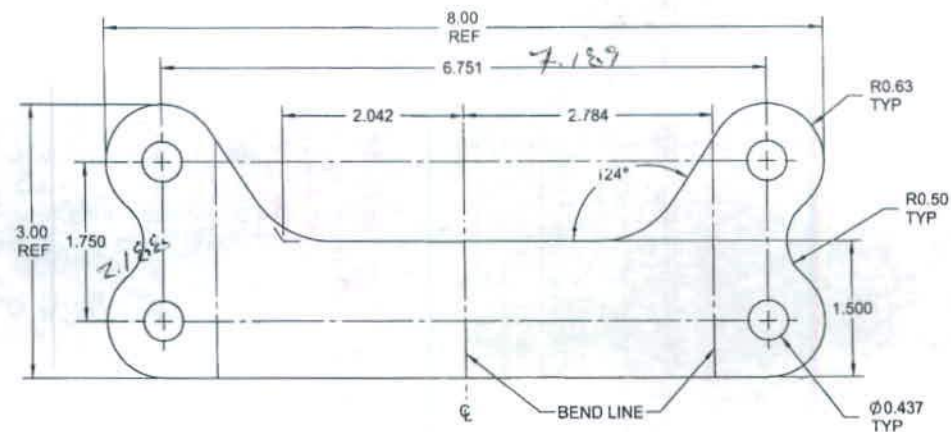
D3405-1F GHW BRACKET FLAT PATTERN



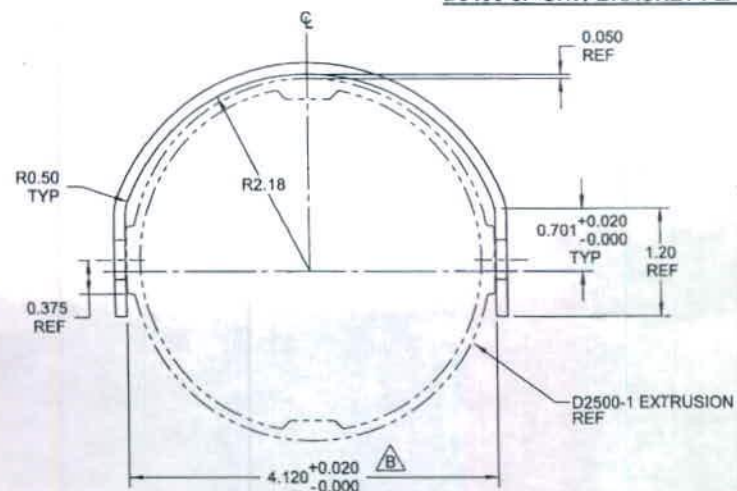
D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

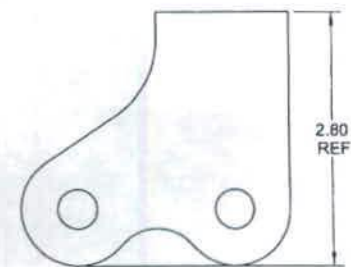
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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